

Date: Monday, 02/06/2008 4:32:22 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM		
Job Number	: 39636A03			Part Number	: D2037101		
Estimate Number	: 10145			Drawing Number	: D2037 REV C3		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/06/2008	S.O. No.	:	Drawing Revision	: C3		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/06/2008		
Previous Run	: 36919C			Qty:	5	Um:	Each
Written By	:			Comment	:		
Checked & Approved By	: <u>SLD 08.6.02</u>			Comment	:		
Comment	: Est Rev:A New Issue 05-11-01 JLM			Comment	:		
Additional Product							
Job Number:				Comment			
Seq. #:	Machine Or Operation:	Description :					
1.0	M304TR0750W049	304 RD Tube .750 x .049W					
							
Comment:	Qty.:	4.1118 f(s)/Unit	Total :	20.5590 f(s)	Comment		
Material:	3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)						
Batch:	<u>M107688</u>						<u>SLB 08/06/23</u>
2.0	BRAKE NC	NC BRAKE					
							
Comment:	NC BRAKE						
1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1							<u>SLB 08/06/23</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1					
							
Comment:	SMALL & MEDIUM FAB RESOURCE 1						
1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037							
2-Flatten ends of D2037-101 tube as required using DT8545							
3-Deburr as required							
4.0	QC5	INSPECT WORK TO CURRENT STEP					
							
Comment:	INSPECT WORK TO CURRENT STEP						
5.0	PACKAGING 1	PACKAGING RESOURCE #1					
							
Comment:	PACKAGING RESOURCE #1						
Identify and Stock							
Location:	<u>ST241A</u>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.07.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

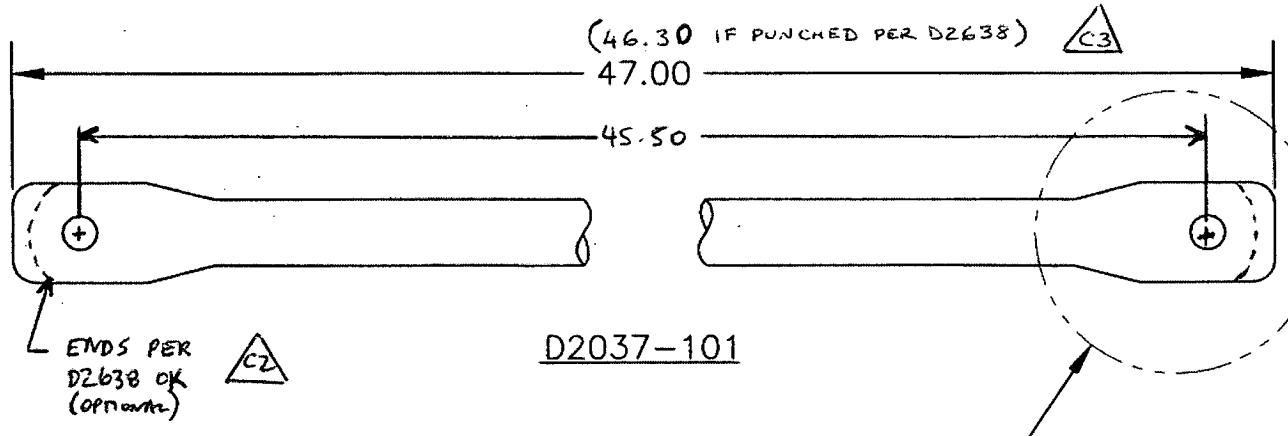
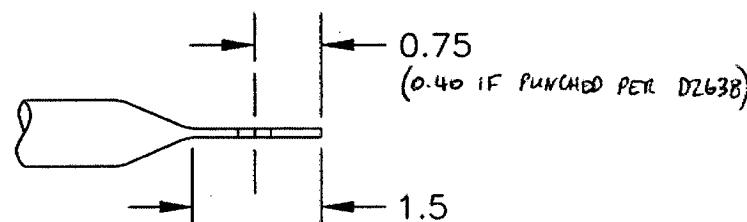
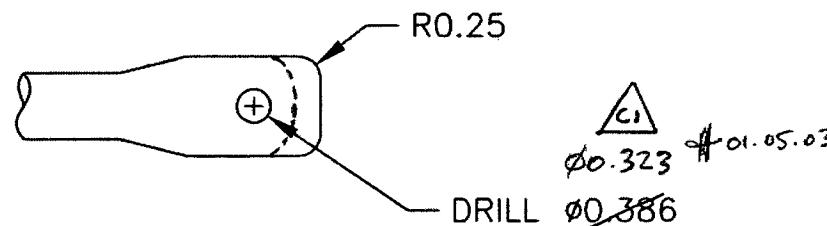
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DRAWN BY DART AEROSPACE LTD
JB RF HAWKESBURY, ONTARIO, CANADA
CHECKED APPROVED DRAWING NO. D2037 SHEET 1 OF 1
DATE 99.06.07 TITLE ARM SCALE NTS

D2037-101DETAIL A**RELEASED**

RE 99.06.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30436403

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WAL

C3	11/05.04.27	ADD 46.30 PUNCHED PER D2638
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